Work Order ID 107550 Page 1 September-27-13 12:47:54 PM 646.3913 Accept Item ID: 646.3913 \*N900040100\* Setup Start **Revision ID:** B107550 Item Name: Shim 9/27/13 Start Qty: 8.00 **Start Date: Cust Item ID:** \*12\* Req'd Qty: 8.00 Required Date: 9/27/13 **Customer:** Reference: Run Process Plan: MCJ Date: 13-40-01 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Reject Sequence ID/ Operation Set Up/ Tool 1D Tool # Plan Accept Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** Draw Nbr **Revision Nbr** 646.3900 N/C 110 0.00 \*110\* 0.00 Waterjet Memo 1-Cut as per Dwg FLOW CNC Waterjet Dwg Rev: 1 Prog Rev: 1/1 2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

12 0

13.11.02

Quality Control

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-	CON	IFORM	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
Operator					·							
Material												
Setup												
Other		1										
Process												
Supplier			l									
Training												
Unapproved							•					
	·				F	AUL	T CATE	GORY				

Landing	Gear	General		_	_	 _
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	_
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio	Г	Outside Dimensions		

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Work Order September-27-13			*1075	550*		Page 2
Item ID: 646 Revision ID: Item Name: Shir	5.3913 m		Accept	*N900040	100* Setu	Stop *NS2*
Start Date: 9/2 Required Date: 9/2 Reference:	7/13 Start Qty: 8.00 7/13 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:		
	rocess Plan:	<del></del> -		Date:	Rur	Start *NR1* Stop *NR2*
Sequence ID/ Work Center ID  130  *130* QC Quality Control	Operation Description QC8- Inspect parts - se	cond check	Set Up/ Run Hours 0.00 DAS 27 0.00 3 9-89	Tool ID Tool #	<del>-</del>	Reject Reject Insp. Qty Number Stamp
140 *140* Outsource3 Outsource process - Cad	Memo	plate per QSI017 4.1.9.1	0.00		_CZ	13/11/06/12
*150 *150* Packaging Packaging	Receive & Inspect for I	Damage & Mat'l Certs	0.00			3/12/4 (2)

Packaging

		<b>5</b> - '	
DQA:	Date:		

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

										QA Closed:	Date	:
Work Order	;				DISPOSITION				AGAINST DI	PARTMENT,	PROCESS	
Part No	**************************************				Rework Scrap Use-as-is		ı	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	D				Work Order Update			Large Fab	Composite	]	Supplier	
Root				Descri	ption of work order update	lr	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator												
Material		:										
etup												
Other						1						
Process						1						
Supplier												
Fraining												
Jnapproved					· · · · · · · · · · · · · · · · · · ·							
					F.	AUL	CATE	GORY				
Landing	g Gear				General				_	_	_	<del></del>
	Bending				Bend		Grain			Ovalized		Pressure/Forced
L	Centre No	ot Concei	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorred	ct _	Weld
L	Crushed/	Crimped			Burrs	Ш	Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at		L	Countersink		Mislabe	eled	·	Positioned V	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Ш	Offset					
	Torque W	Vaves in E	Extrusio	n _	Drawing		Out of 0	Calibration			·	
	Turning S	Sequence			Finish		Out of 9	Sequence				
Ī	Wave/Tw	vist in Tul	эе		Folio		Outside	Dimensions				

Work Order ID 107550 \*107550\* Page 3 September-27-13 12:47:54 PM Item ID: 646.3913 Accept \*N900040100\* Setup Start **Revision ID:** Shim Item Name: \*8\* Start Oty: 8.00 **Start Date:** 9/27/13 **Cust Item ID:** Required Date: 9/27/13 Req'd Qty: 8.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: **Approvals:** Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp DAS 160 QC5- Inspect part completeness to step on W/O \*160\* Memo Quality Control Identify as per dwg & Stock Location: 57535 0.00 170

\*170\*

Packaging M

Memo 0.00

Packaging \*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND

REV\*\*\*

180

QC21- Final Inspection - Work Order Release 0.00

\*180\*

QC

Memo

0.00

Quality Control

DAS

DAS 28.... 3-12-4

13/12/9

1/3-12-5

					-				DQA:	Date:		
NCR: Yes	/ No				WORK ORDER NON-C	CONFO	RMANCE / U	JPDATE	QA Closed:	Date:		
Work Order:					DISPOSITION	DISPOSITION AGAINST DEPARTMENT/PROCESS						
Part No. NCR No.	No				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Crosstube  Machining Small Fab  ermoforming Finishing  Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root				Descri	ption of work order update	Initia		Action	Sign &			
Cause	Date	Step	Qty	. (	or Non-conformance	Chief E	ng D	escription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												

main	ig Gear	 General	 _			 _
	Bending	Bend	Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	L	Part Moved	
	Heat Treat	Countersink	Mislabeled		Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset			
	Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence			
ſ	Wave/Twist in Tube	Folio	Outside Dimensions			

**FAULT CATEGORY** 

## **Picklist Print**

September-27-13 12:47:53 PM

Work Order ID:

107550

Parent Item:

646.3913

Parent Item Name:

Shim

**Start Date:** 9/27/13

Required Date: 9/27/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.032 C1095 Blue Tempered Sp.	ring Steel Sheet .032	Purchased	No			110	sf	8.5000	0.02	0.1684208	An	13:	11.00
				Location		Loc Oty	Lo	oc Code					
				MAT022		8.5							

2 8.5 123537 8.5

123537 ---

24

											DQA:	Dat	te: _	
NCR: Y	es /	No .				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UPDATE					
											QA Closed:	Dat	te:	
						DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
Work Orde	er:					ъГ	٦		sitte La Company	_	1	Water Jet	$\neg$	·
						Rework	-	1,	Skid-tube Crosstub  Machining Small Fa	_		<b>;</b>	$\dashv$	Engineering Quality
Part N	NO					Scrap Use-as-is	-	1	Machining Small Fa noforming Finishin	<u> </u>	1	d. Eng. Coor. re/Packaging	$\dashv$	Other
NCR N	No.					Work Order Update	-	mem	Large Fab Composit	~ —	Rec/Stol	Supplier		
NCKT	<b>1</b> 0			<del></del>		Work Order opdate			composit		]	Supplier		
Root					Descri	ption of work order update		Initial	Action	-	Sign &			
Cause		Date .	Step	Qty	,	or Non-conformance	Cr	nief Eng	Description		Date	Verification	1	QC Inspector
Doc/Data												-		
Equip/Tooling														
Operator			İ											
Material														
Setup	Ш						ļ							
Other	Ц													
Process														
Supplier	Ш			ļ										
Training	Ш													
Unapproved				<u> </u>	<u> </u>									
			-				AUI	LT CATE	GORY					
Landi	ng Gea					General		J		_	Ovalized	Г	一.	)
	⊢	nding			o /s	Bend	$\vdash$	Grain		$\vdash$	4	<u> </u>	_	Pressure/Forced
	$\boldsymbol{H}$		ot Concei	ntric to	<sup>0/5</sup>  -	BOM/Route	$\vdash$	Hardwa		-	Over/Under			Temperature/Cure Weld
Cracks Broken/Damaged				$\vdash$	<b>-</b> 1 `	ion Incomplete	-	Part Incorre		-	weia Wrong Stock Pulled			
Crushed/Crimped Burrs				→	$\vdash$	Mainte	cions Incomplete/Unclear	$\vdash$	Part Lost/Mi Part Moved	122111B [	'لـــا	wrong Stock Pulled		
Cuffs Contamination Countersink				Countersink	-	Mislabe		$\vdash$	Positioned V	Vrong				

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

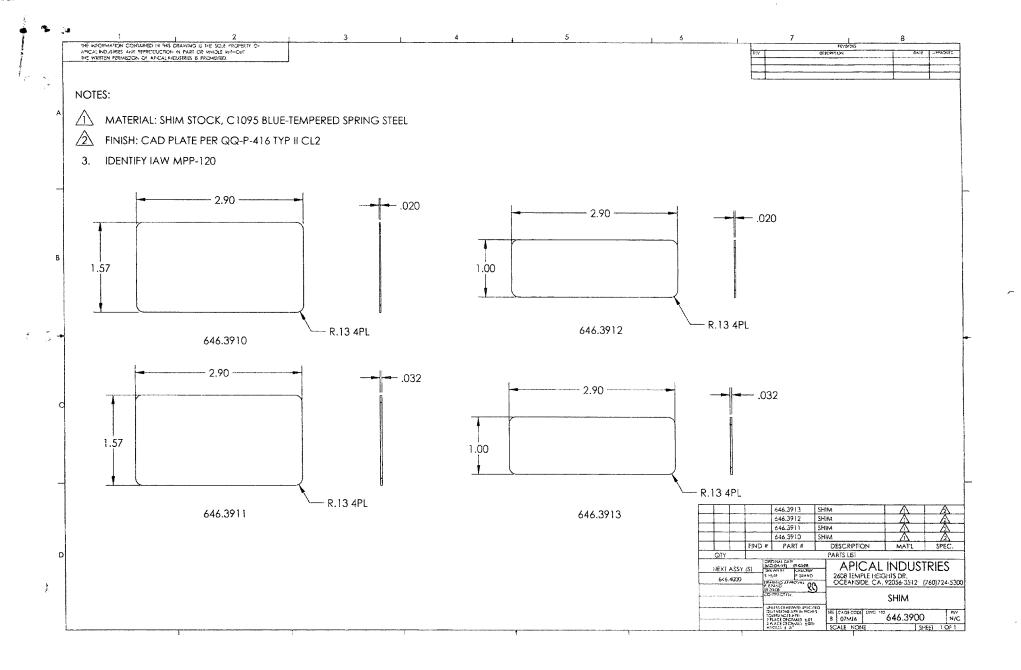
DART AEROSPACE LTD	Work Order:	107550
Description: Shim	Part Number:	646.3913
Inspection Dwg: 646.3900 Rev: N/C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.005	1,00"	_		V	DKM-01
2.90	+/-0.005	2.90"	_			
0.032	+/-0.005	2,90"			<u> </u>	
			<del></del>			
			DAS			

Measured by:	Audited by:	27 9-89	Preliminary Approval:
Date: /3 ·1/ · 02	Date:	13 11 CY	Date:

Rev	Date	Change	Revised by ∧	Approved
Α	12.11.30	New Issue	KJ C	/AA
		•	1//	•



## **CERTIFICATE OF** CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Dec-02-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

130256

**INVOICE #:** 

68742

CONTRACT OR

**PURCHASE ORDER #** 

PO21961

**DESCRIPTION:** 

SHIM

QTY

12

P/N# 646.3913

107550

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-1051.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

**Approved Inspector:**